



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST2854-3
Job Sheet 173094



Part No: RBST2854-3

Job Qty: 4 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/26/18

Job Tracking No:

Due Date: 4/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST2854 Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/9/18	0.00	0.00	Start Up Machining-3		18-4-7
110	CNC Lathe	4 pcs		4/9/18	0.00	2.00	MORI SL-154		18-4-7
120	QC	4 pcs		4/9/18	0.00	0.00	QC2 Machining-4		18-4-7
122	Mill Conv	4 pcs		4/9/18	0.00	0.00	Mill Conv 1		18-4-7
124	QC	4 pcs		4/9/18	0.00	0.00	QC2 Machining-2		18-4-7
130	QC	4 pcs		4/9/18	0.00	0.00	QC8 Machining-4		18-4-7
180	Packaging	4 pcs		4/9/18	0.00	0.00	Packaging3-1		18-4-7
190	QC21-SA	4 Ea		4/9/18	0.00	0.00	QC21		18-4-7

Part Op 110 - 1-Machine as per DWG. FB987 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 122 - 1-Machine as per DWG. DWG REV: _____ 2-Debur

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.500	Bronze C63000 Round Bar 1.500"	.1120 ft (.028 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.500	0	3	0

Allocated Container Detail			
Qty	Container No	Location	Init
0	S059004	start up machining-3	

Part Specifications

Specifications could not be found.



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RBST2854-3
Job Sheet 173094



Part No: RBST2854-3

Job Qty: 4 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST2854 Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/8/18	0.00	0.00	Start Up Machining-3		JL 18-4-7
110	CNC Lathe	4 pcs		3/9/18	0.00	2.00	MORI SL-154		JL
120	QC	4 pcs		3/9/18	0.00	0.00	QC2 Machining-4		JL
130	QC	4 pcs		3/9/18	0.00	0.00	QC8 Machining-4		
180	Packaging	4 pcs		3/9/18	0.00	0.00	Packaging3-1		
190	QC21-SA	4 Ea		3/9/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Machine as per DWG. FB 987 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.500	Bronze C63000 Round Bar 1.500"	.1120 ft (.028 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.500	0	3	0

5039726 .094

Part Specifications

Specifications could not be found.

Plex 2/26/18 10:08 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartaero.com
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Container No: S059005



Part: RBST2854-3

Job No: 173094

Serial No/Batch: S059005

Revision: 1

Inspector:

Date: 04/07/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

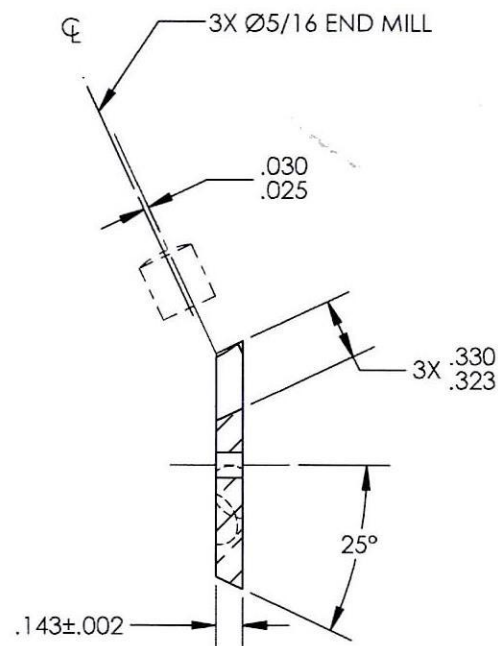
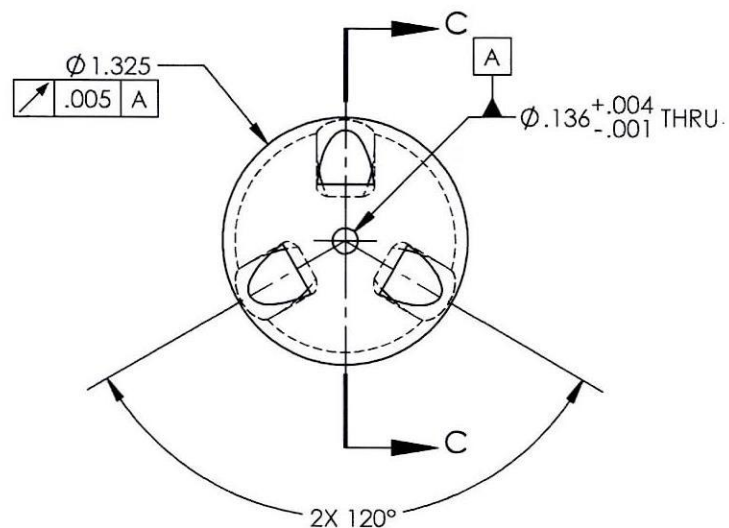
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				



SECTION C-C

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173074M05
1802-26

③
RETAINER

DART AEROSPACE	
TITLE TR-ROLLER SWAGING TOOL	
DWG NO. RBST2854-3	REV 1
MAT'L BRONZE RND BAR	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D. Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC
SCALE 1:1	DATE 5/20/2013
SHEET 3 OF 10	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																		
Description Work Order Deviation				Disposition																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								



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Process Routings

RBST2854-3 Operations

Retainer

	Op No	Operation	Description	Workcenters	Supplier	Type	Weight (lbs)	BOM	Special Comments	Location	
	90	Start up Operation		Start Up Machining-3 (Start Up Machining)		Production	.0000	MT-BRONZE-C63000-R1.500			
	110	CNC Lathe	1-Machine as per DWG. FB987 FOLIO REV: _____ DWG REV: _____ 2-Debur	MORI SL-154 (MORI SL-154 LATHE)		Production	.0000				
	120	QC		QC2 Machining-4 (QC2-Inspect parts off machine FAI/FAIB)		Production	.0000				
	122	Mill Conv	1-Machine as per DWG. DWG REV: _____ 2-Debur	Mill Conv 1 (Manufacture as per dwg)		Production	.0000				
	124	QC		QC2 Machining-2 (QC2-Inspect parts off machine FAI/FAIB)		Production	.0000				
	130	QC		QC8 Machining-4 (QC8-Inspect parts - second check)		Production	.0000				
	180	Packaging		Packaging3-1 (Identify as per dwg & Stock Location: _____)		Production	.0000				
	190	QC21-SA		QC21 (QC21- Final Inspection - Work Order Release)		Production	.0000				